

Date: Tuesday, 12/20/2005 2:52:07 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD ASSEMBLY LH
Job Number	: 25300		
Estimate Number	: 10800		
P.O. Number	: N/A	Part Number	: D350600141
This Issue	: 12/20/2005 S.O. No. : N/A	Drawing Number	: D3186 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: 25299	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/20/2006
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	1 Um: Each
Comment	: Est Rev:D 05.04.14 Incorporated procedures from D3187-1/-2 K J/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG002

D14 06K1/30 ①

2.0	25300A	SPACEPOD BODY LH
-----	--------	------------------



Comment: Sub-Component SPACEPOD BODY LH

3.0	25300B	SPACEPOD DOOR LH
-----	--------	------------------



Comment: Sub-Component SPACEPOD DOOR LH

4.0	D31871	Spacepod Floor
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3187-1	Floor	<u>B22929</u>
1	D3186-1	Door (ref)	<u>25300B</u>
1	D3188-1	Body(ref)	<u>25300A</u>

5.0	ALS41032130	Insert
-----	-------------	--------



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
28	ALS4-1032-130	Insert	<u>M 18293</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25300

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-1. Open holes in floor to Ø0.297". Install inserts as per Dwg D3188.

ml 06/05/01

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Don't need inspect 5 ac here

PTD

N/A ml 06/04/12

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open holes in D3187-2 as per Dwg 3187

2-Deburr D3187-2

ml 06/05/01

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Bobase 01

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-05-16

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06-05-16

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-05-18

13.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total: 5.9010 sf(s)

Pick:

Qty Part Number

Description

Batch

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
02/04/12	7	don't need inspection QC5. take out Permanent Change	ml					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 2:52:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25300

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.62SF D2986

Neoprene Foam

B24628

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

ml
06/04/12

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch:

M100008

JAD 06:05:17

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Don't need this inspect here
06-05-18
1/19 AM/06/18

16.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2179 Hinge Bracket Plate

B21490

17.0

D2219

Door Prop Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2219 Door Support Bracket

B14027

18.0

D2228

Backing Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2228 Backing Plate

B14028

19.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 D2237 Strike Plate

B24561

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06/04/12	15	Don't need this QCS there. Move to after step 43 N/A <i>[Signature]</i> Permanent change	<i>[Signature]</i>			<i>[Signature]</i> <i>[Signature]</i>		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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Process Sheet

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Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25300

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D2464

3/4 Seal



Comment: Qty.: 10.9305 f(s)/Unit Total: 10.9305 f(s)

Pick:

Qty Part Number Description Batch

1 D2464-125" neoprene Seal B25153

21.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2586 Latch B25050

22.0

D2588

~~Bracket~~ mounting channel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

~~3 D2586 Latch~~ 1 D2588 B21509

23.0

D2589

Keys, Key Chain



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

~~1 D2588 Mounting Channel~~ 1 D2589 B23083

24.0

D2621

Latch Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D2621 Latch Plate B25474

25.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2857-1 Hinge Bracket B26033

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod-Mgr	Approval QC Inspector
06/04/12	22 and 23	Permanent Change These Steps are wiped - Re-Do		<i>[Signature]</i>	06-05-31		<i>[Signature]</i>	<i>[Signature]</i> 06-05-18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25300

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2857-2 Hinge Bracket B26034

27.0

D2977

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2977 Hinge Bracket B14106

28.0

D2978

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2978 Hinge Bracket B14107

29.0

D2982041

Prop Arm Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2982-041 Prop Arm Assembly B24627

30.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3015-3 Lock Nut B22365

31.0

A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 A3235-020-935 Washer M18332

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25300

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN526C832R9

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN526C832R9 Screw M15602

33.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN960JD10 Washer M19521

34.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD516 Washer M15927

35.0

AN960JD8

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 AN960JD8 Washer M1989

36.0

AN960JD8L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960JD8L Washer M6956

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 2:52:08 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 25300

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

MS20426AD45

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batc

6 MS20426AD4-5 Rivet M3459

PTO

38.0

MS21042L08

Nut



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number Description Batch

14 MS21042L08 Nut (or -8) M15003

PTO

39.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 MS21042L3 Nut (or -3) M15539

40.0

MS270390810

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-0810 Screw M5865

X

41.0

MS27039125

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 MS27039-1-25 Screw M17570

X

42.0

SL69BS

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:



Qty Part Number Description Batch

1 SL69-BS Ball Stud M16948


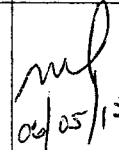
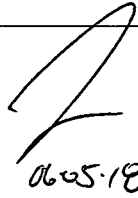

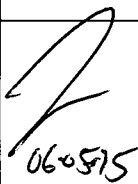
✓

✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06/04/12	37	missing on New w/o <u>ADD them</u> 2 Rivets MS 20426 AD 4-6 <u>M 2566</u>		ml				 060518	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 0605129
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			
06/05/15	38	Qc ask to change 2 nuts MS 21042608, 2 nuts badly damaged from socket or wrench when Assembling		Scrap 2 and replace by new one		 06/05/15	 060518		 060515

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 2:52:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 25300

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-2 door with D3188-2 body as per Dwg ICA-D350-600

m 06/05/10 *PTO*

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188-2 & QSI 005 4.4

Batch: M100652

FC 06 05 17

45.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

060510-1

46.0

K10018

Spacepod Hardware Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 K10018

Spacepod Hardware Kit

26013

1 D3187-1(Ref)

Spacepod Floor

B22929

06/05/26 (1)

47.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/05/26 (1)

48.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location:

PPP Rev:

C

06/05/26 (1)

49.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/20 (1)

Job Completion



0605-20

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06/04/12	43	Need inspection QCS after step 43 Permanent change		ml					
		Re-inspected by 06-05-18						06-05-18	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED GP	DRAWING NO. D3186	REV. A SHEET 1 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
AI	04.11.04	Now 4.5" WIDE UNIDIRECTIONAL	

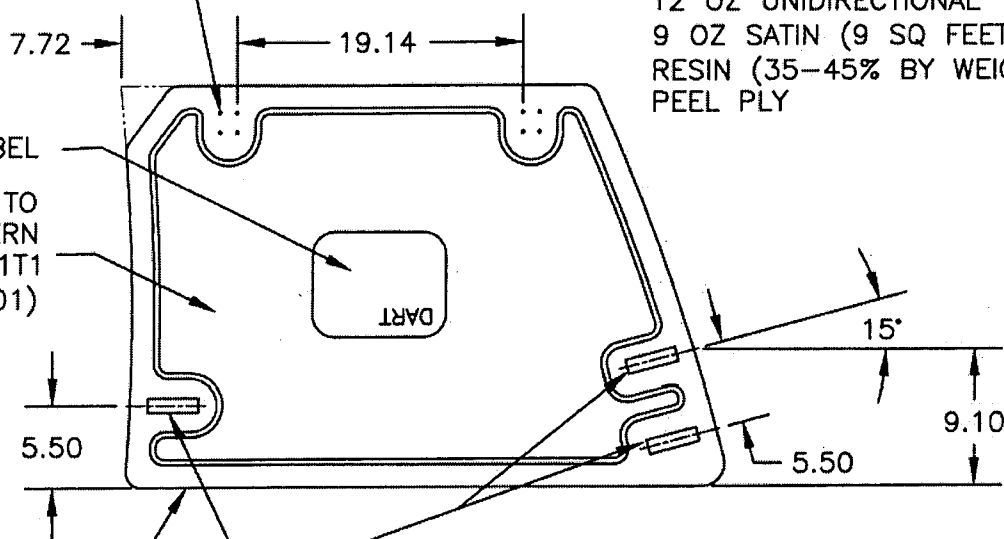
DRILL 8 HOLES $\phi 0.171$
PER SCRIBE LINES OF
MOLD DT8005 (REFER
TO DETAIL B ON PAGE 3)

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

D0600-145 LABEL

ROUTER FOAM TO
ROUTER PATTERN
D3186-1T1
(P/N D3186-101)



12 OZ UNIDIRECTIONAL
4.5" WIDE 5" WIDE ALONG
OUTSIDE EDGE

CUT 3 PLACES AS SHOWN IN DETAIL A
ON PAGE 3

RELEASED
#03.04.22

D3186-1

NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

SHOP COPY

RETURN TO

ENGINEER

25300

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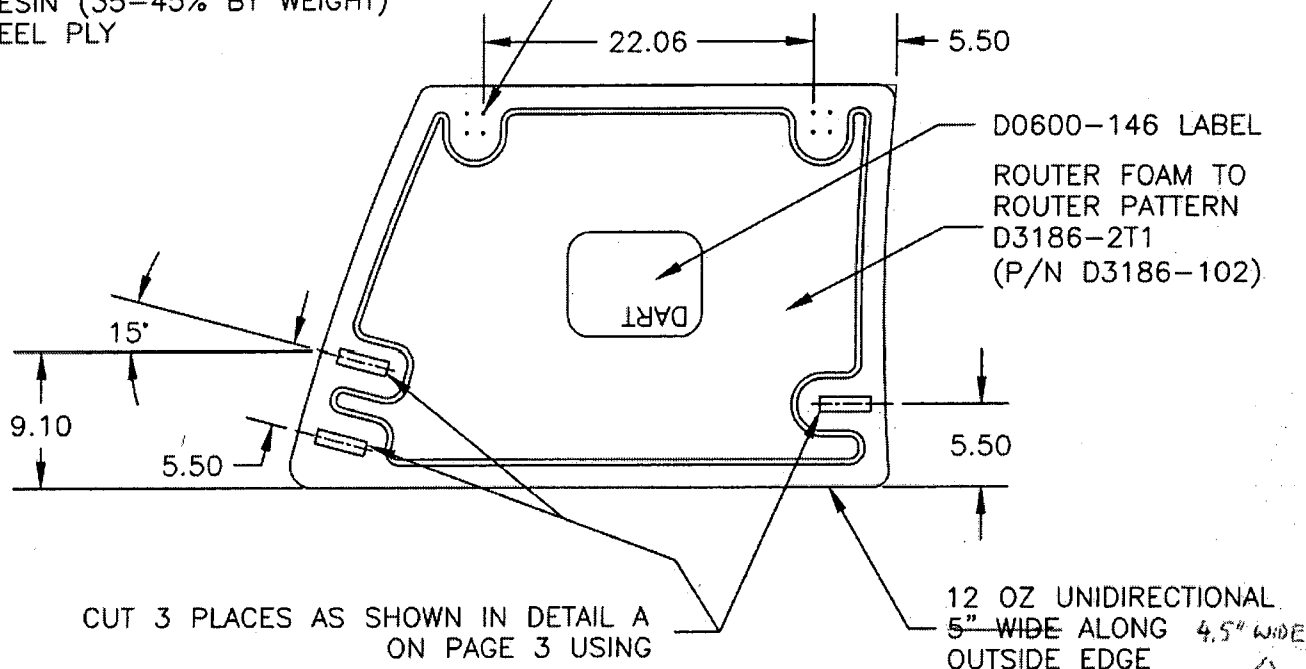


DESIGN #	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3186	REV. A SHEET 2 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

DRILL 8 HOLES $\phi 0.171$
PER SCRIBE LINES OF
MOLD DT8006 (REFER
TO DETAIL B ON PAGE 3)



RELEASED
#030422

D3186-2

NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

NO. 25300

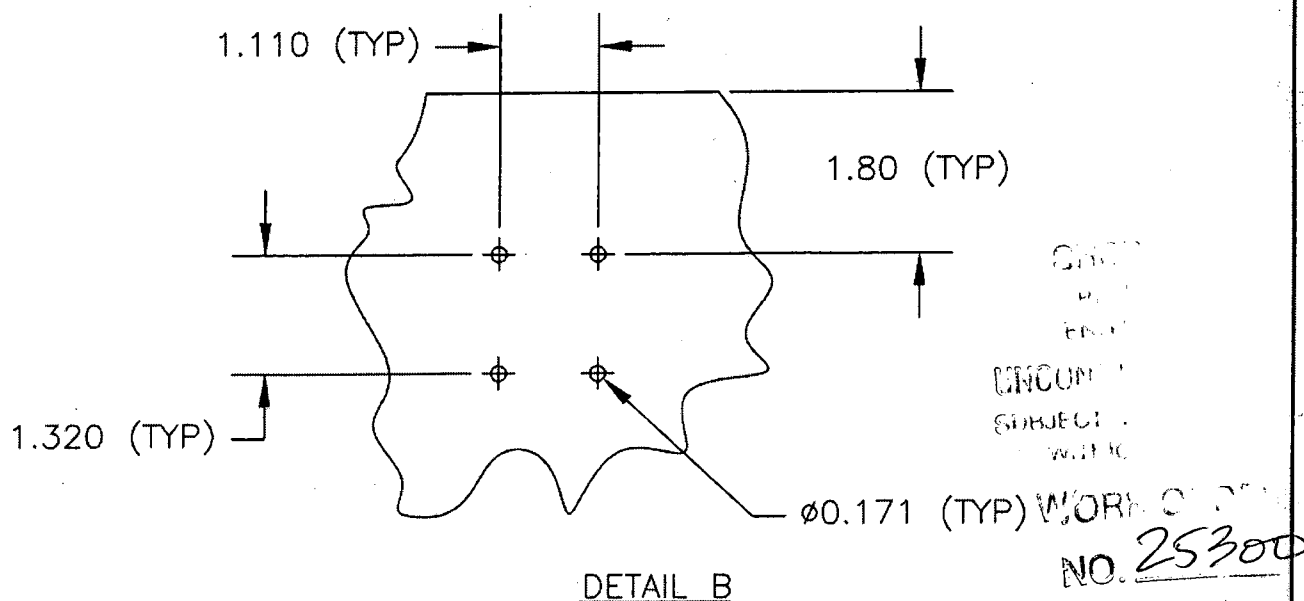
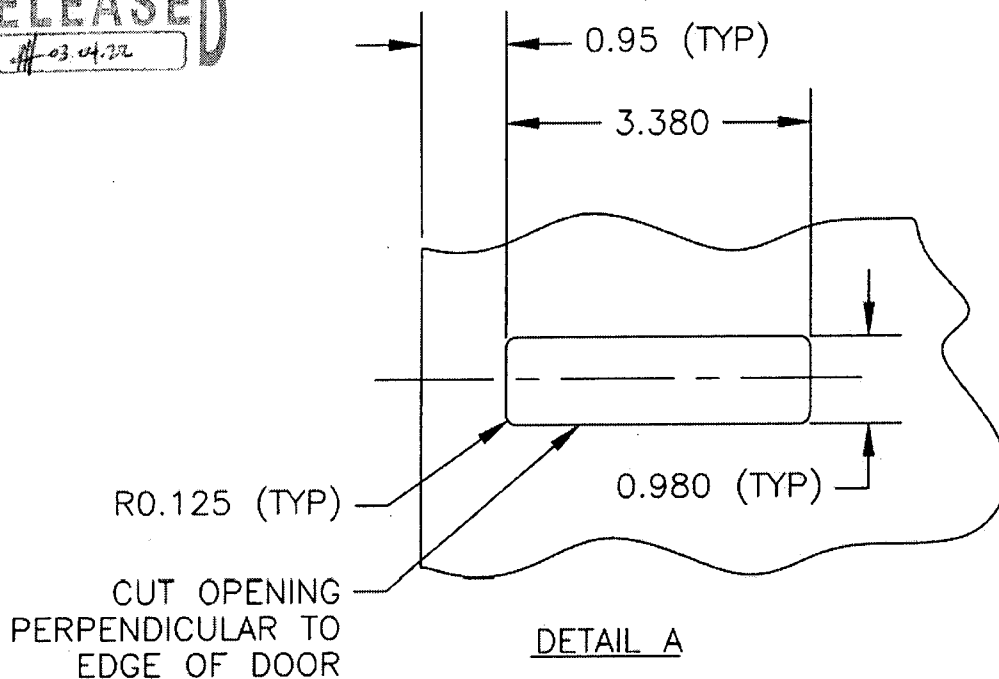
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DESIGN #	DRAWN BY JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED JP	DRAWING NO. D3186	REV. A SHEET 3 OF 3
DATE 03.03.27		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED
03.04.22



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DESIGN JB	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3188	REV. A SHEET 1 OF 7
DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	

RELEASED
03.04.22

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

<u>PART</u>	<u>LAYUP</u>	<u>TRIM AND DRILL</u>
D3188-1	DT8003	DT8501
D3188-2	DT8004	DT8502
D3188-3	DT8500	DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

2.000.0000

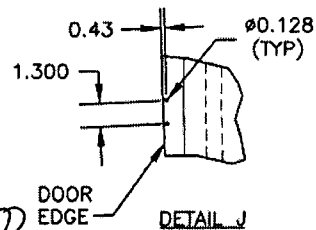
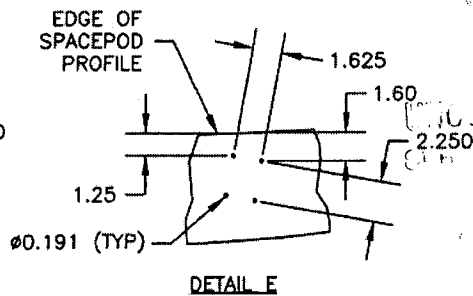
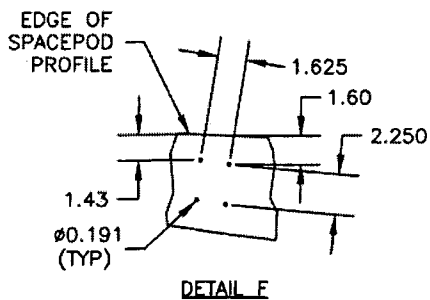
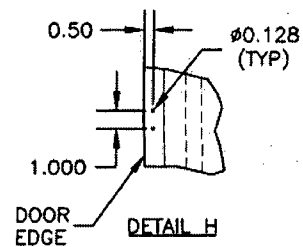
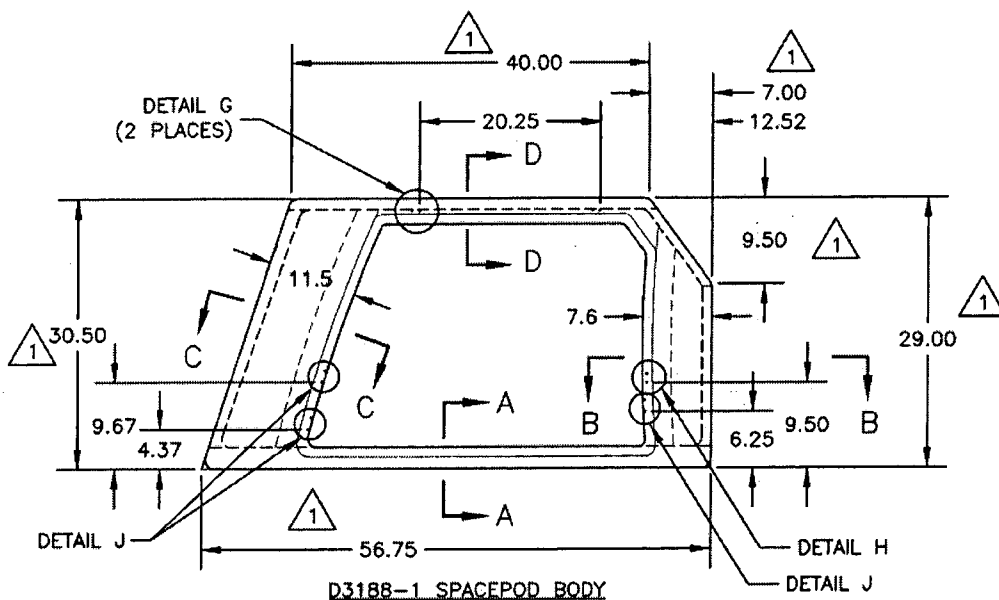
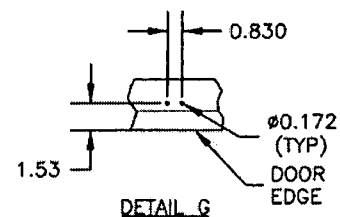
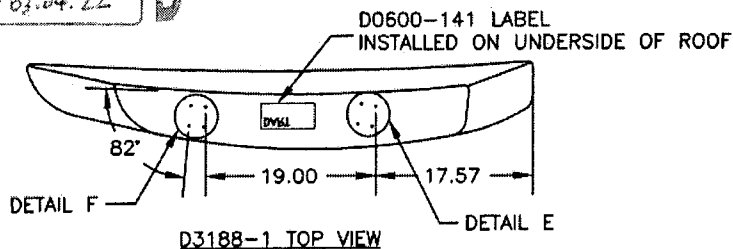
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DATE 03.04.03	TITLE SPACEPOD BODY		SCALE NTS

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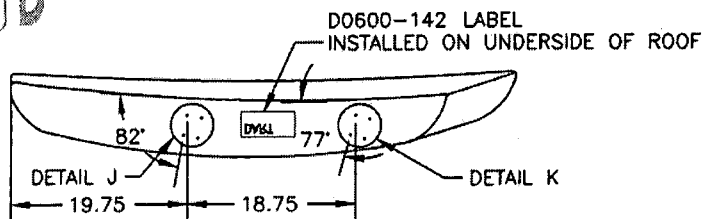
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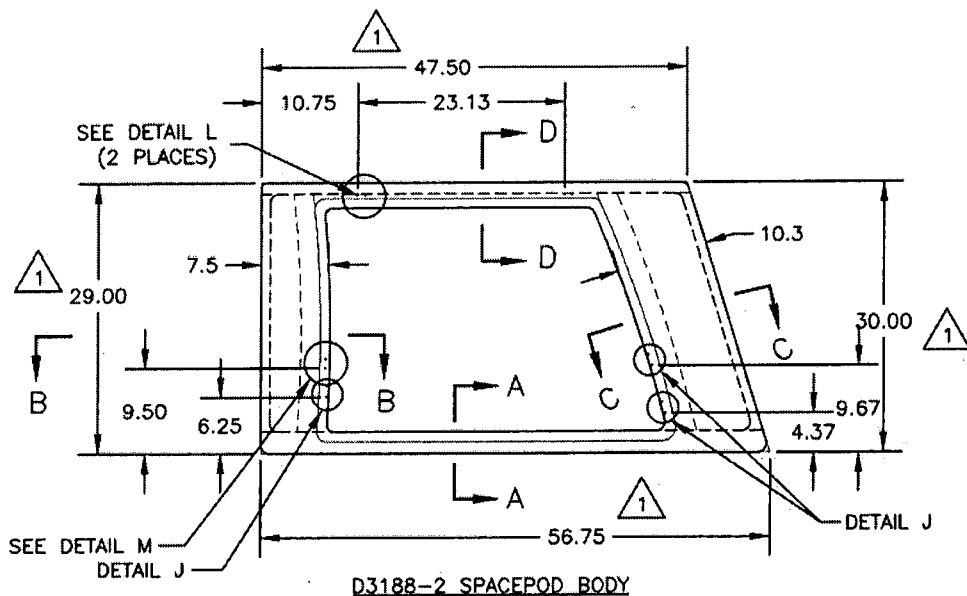


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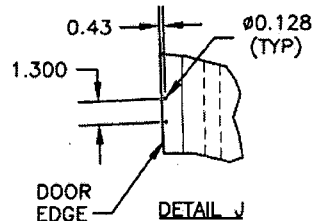
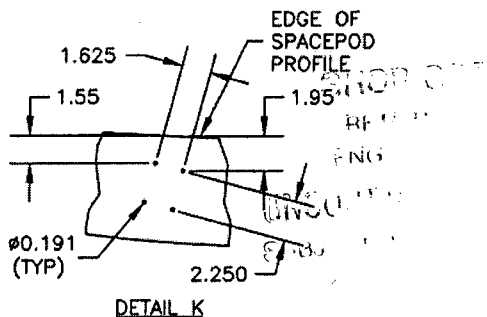
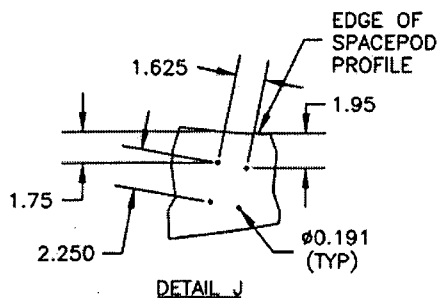
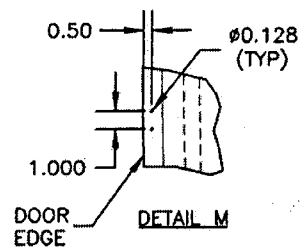
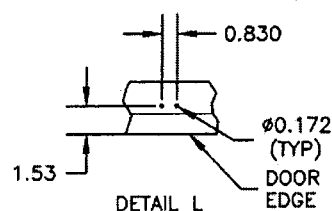
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D3188-2 TOP VIEW



D3188-2 SPACEPOD BODY



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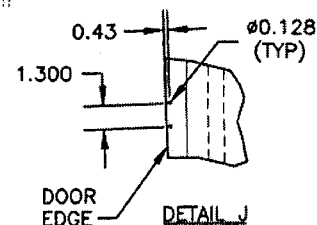
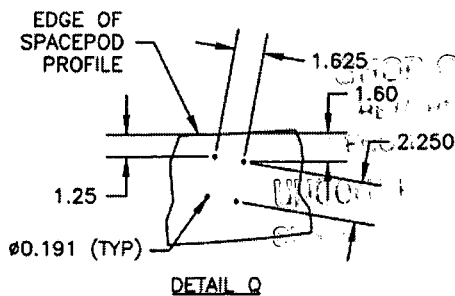
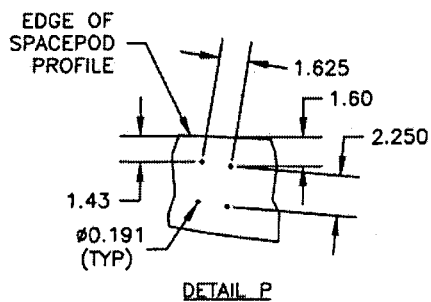
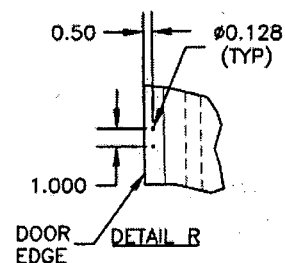
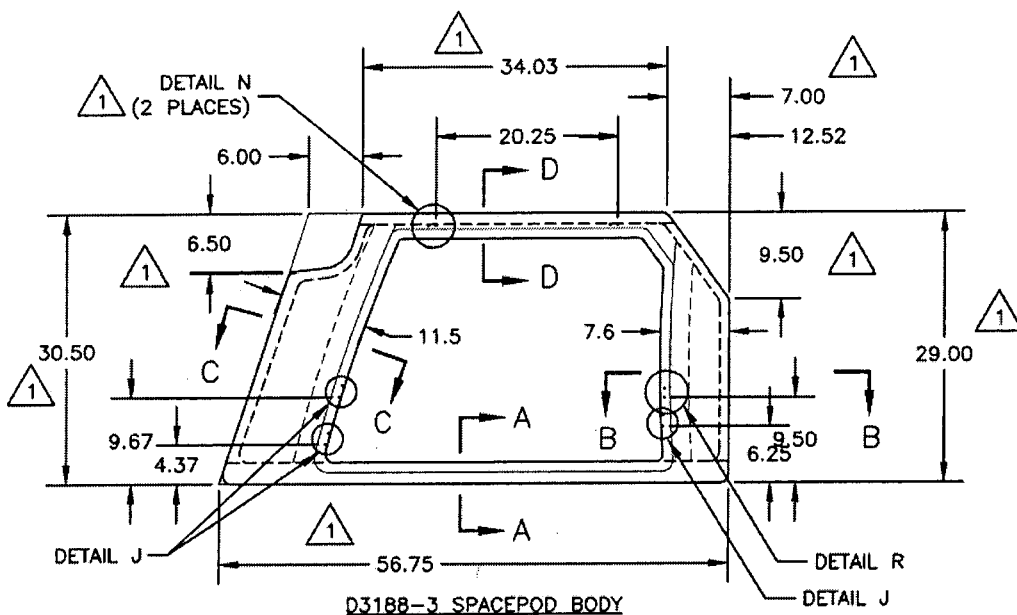
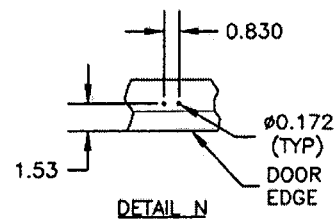
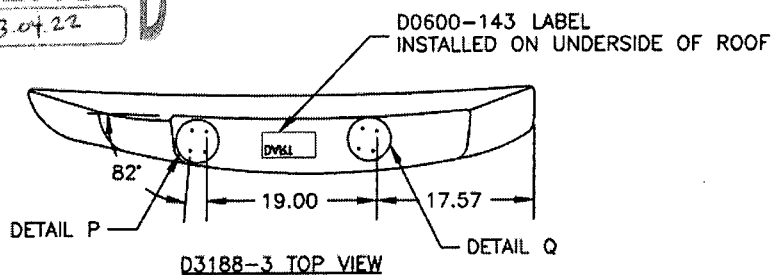
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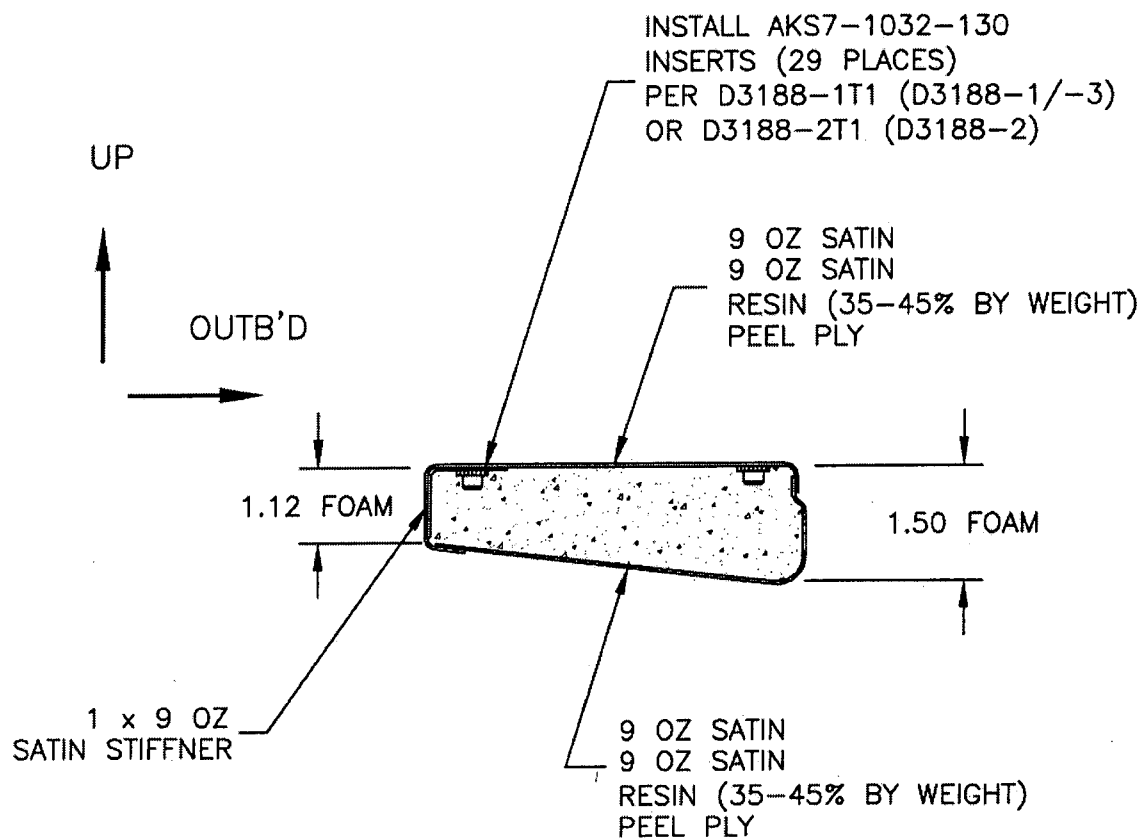
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SECTION A-A
(TYPICAL FLOOR SECTION)

CHOP
RET
ENG

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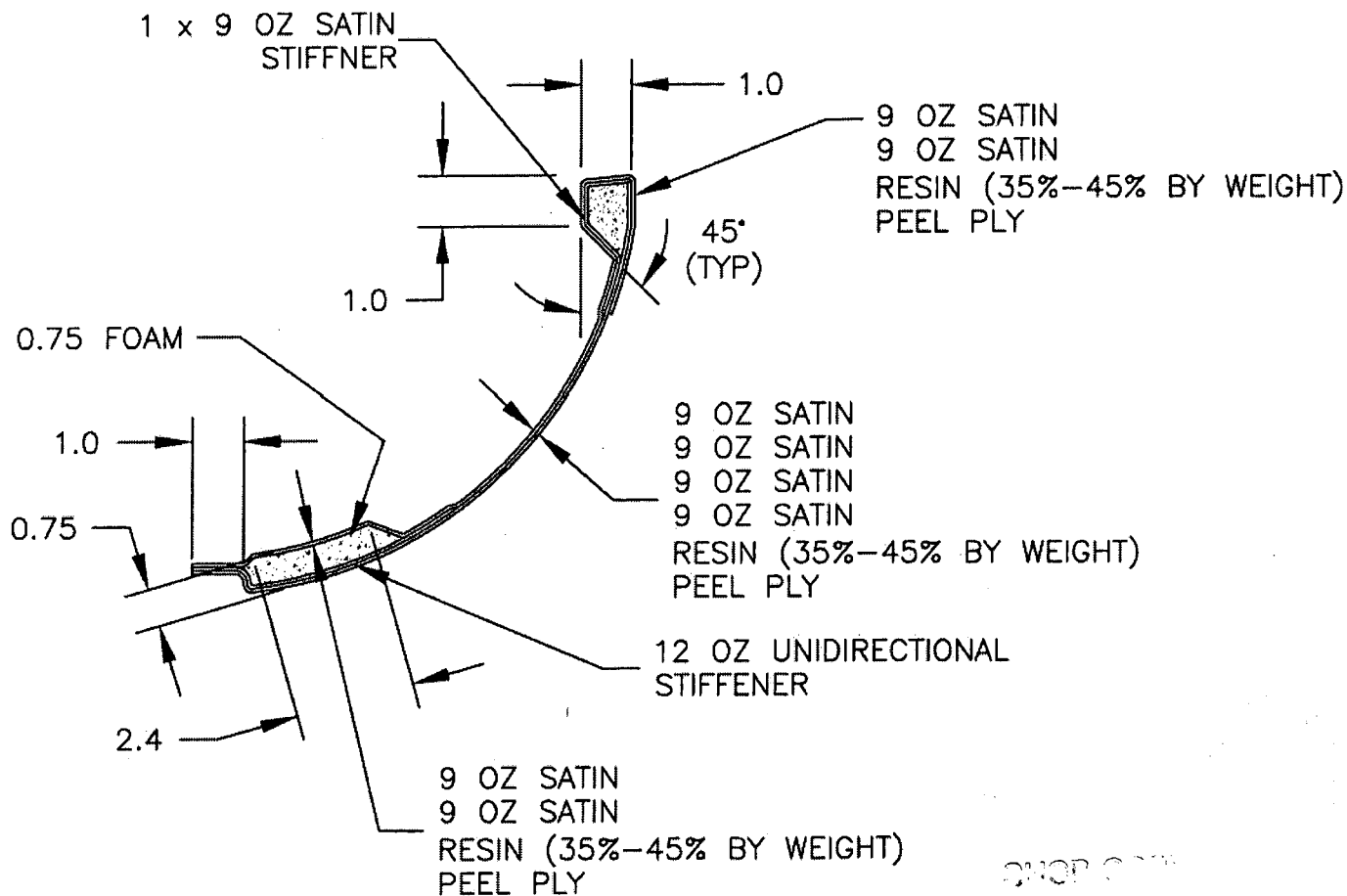
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SECTION B-B
(SECTION C-C SIMILAR)

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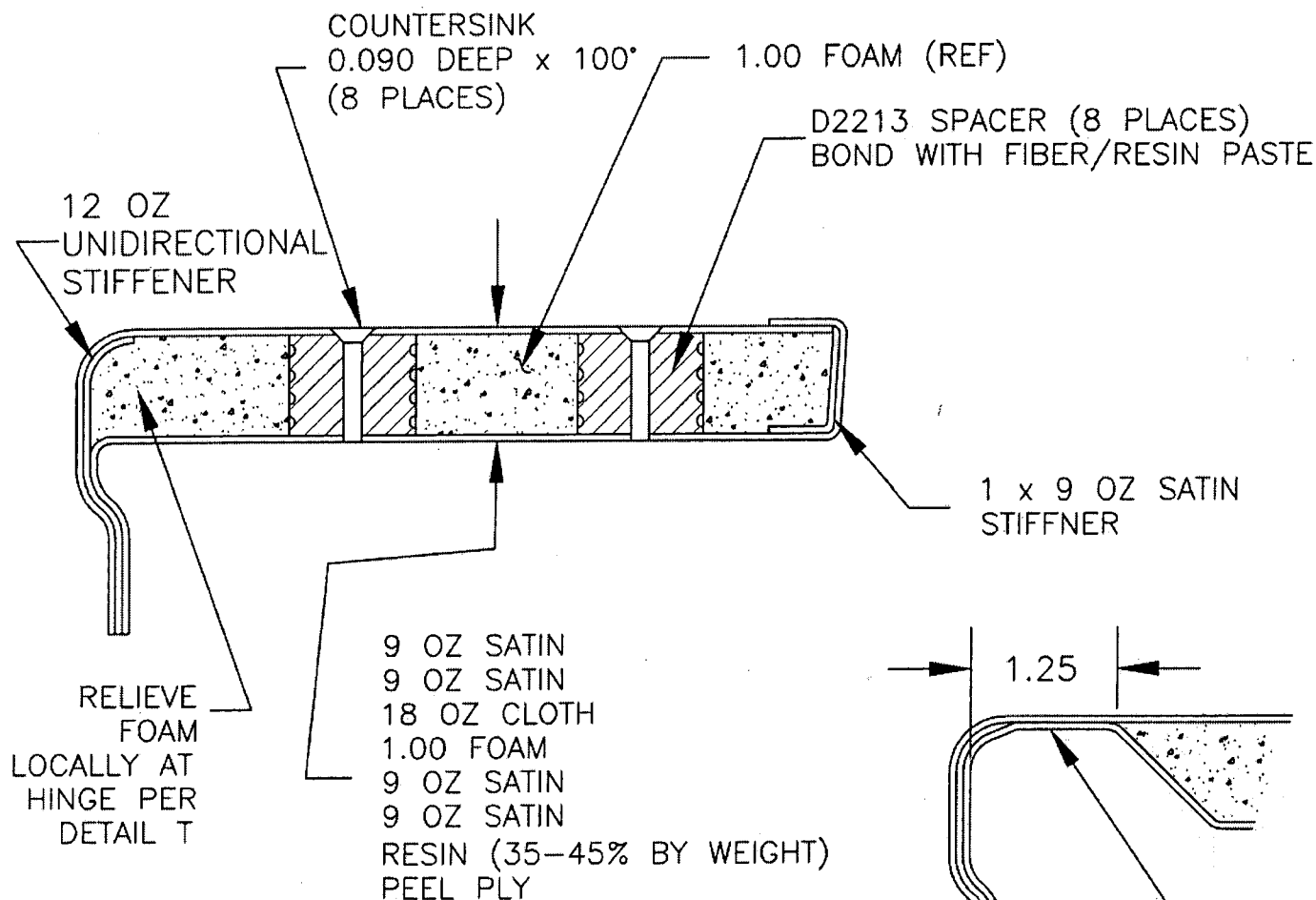
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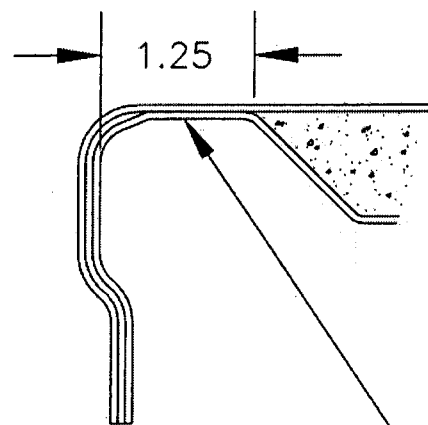


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SECTION D-D
(TYPICAL ROOF SECTION)



RELIEVE AS SHOWN
3" LONG CENTERED
ON HINGE

DETAIL T

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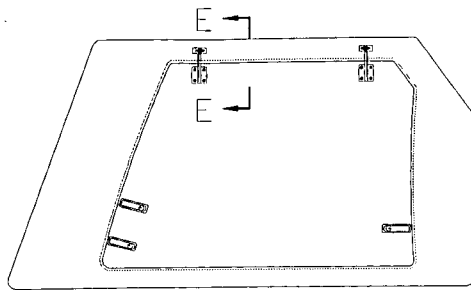


FIGURE 3. LOOKING AT OUTSIDE OF
D350-600-145 DOOR
(D350-600-146 SIMILAR AND OPPOSITE)

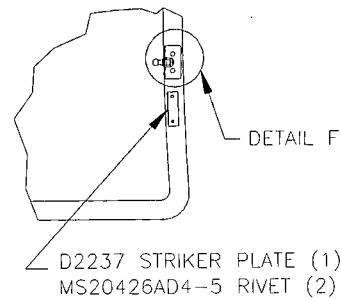


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

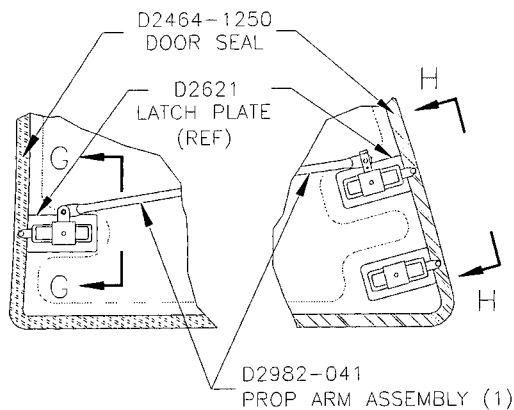
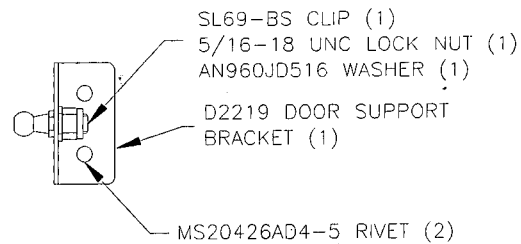


FIGURE 5. LOOKING AT TYPICAL INSIDE
OF D350-600-145/-146 DOOR



DETAIL F

TC Accepted

MAY 07 2003

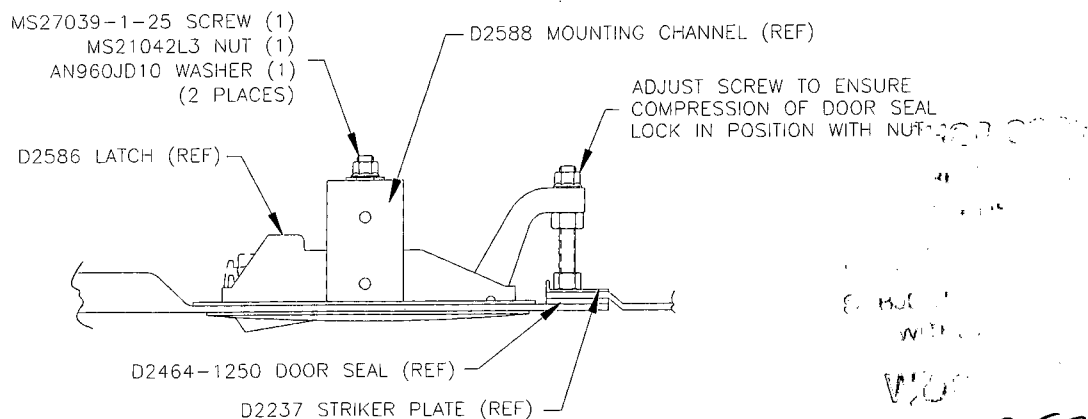
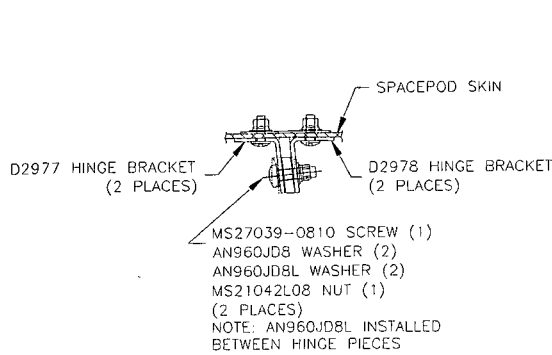


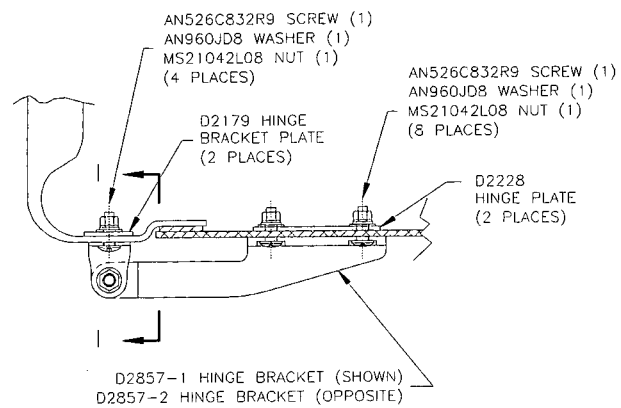
FIGURE 6. TYPICAL LATCH INSTALLATION

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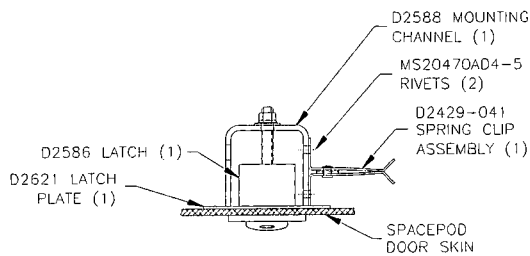
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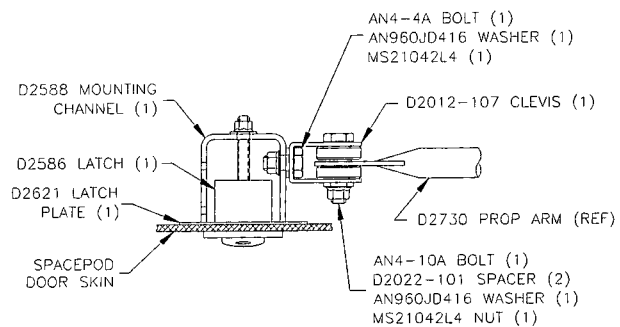
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.

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MAY 07 2003

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